

Date: Monday, 3/26/2007 2:58:55 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LH ACTUATOR ASSEMBLY
Job Number : 31450	
Estimate Number : 12761	
P.O. Number : N/A	Part Number : 41232 200 001 001
This Issue : 3/26/2007 S.O. No. : N/A	Drawing Number : 41232-200-001 REV IR
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : IR
Previous Run : N/A	Material : N/A
Written By : <u>JA</u>	Due Date : 4/2/2007
Checked & Approved By : <u>JA 07.03.27</u>	Qty: 5 Um: Each
Comment : Est Rev: A New Issue 07-02-28 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	MS208224	elbow
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

elbow

Batch: M 103688

SB 07/04/10

④

2.0	124K002 4CR 0545	Hose ass'y-Step Actuator
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Hose ass'y-Step Actuator

BATCH: M 104042

3.0	AN8424D	Elbow
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Elbow

Batch: M 104016

4.0	41232 200 007 001	Brass Cylinder Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Brass Cylinder Assembly

Batch: B 30942

SB 07/04/10

④

5.0	41232 200 003 001	Spring (Step Actuator)
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Spring (Step Actuator)

Batch: B 30944

JA 07-04-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/26/2007 2:58:55 PM

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LH ACTUATOR ASSEMBLY

Job Number: 31450

Part Number: 41232 200 001 001

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS1699623

cap screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

cap screw

Batch: M 103934

7.0

AN3154R

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Nut

Batch: M 17564

8.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Batch: ~~M 103338~~ M 103338

9.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Batch: M 103641

10.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Nut

Batch: M 102658

11.0

AN322A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Batch: M 3413

12.0

41232 200 005 003

Spacer (Step Actuator)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer (Step Actuator)

Batch: B 31022

SPB 07/04/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/13

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LH ACTUATOR ASSEMBLY

Job Number: 31450

Part Number: 41232 200 001 001

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

41232 200 002 005

pivot arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

pivot arm

Batch: B 31021

① H 103305

14.0

41232 200 002 003

latch



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

latch

Batch: B 31020

① H 103305

15.0

41232 200 002 001

tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

tube

Batch: B 31019

JB 07/04/13 (5)

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg 41232-200-001

2-Torque as per Dwg 41232-200-001

JB 07/04/13 (5)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JB 07/04/13 (5)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C 7/9/13 (5)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JB 07/04/13 (5)

Job Completion



U 07/04/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

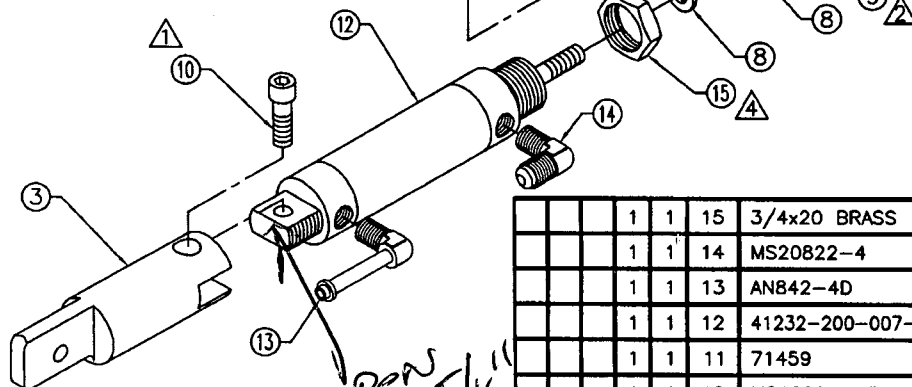
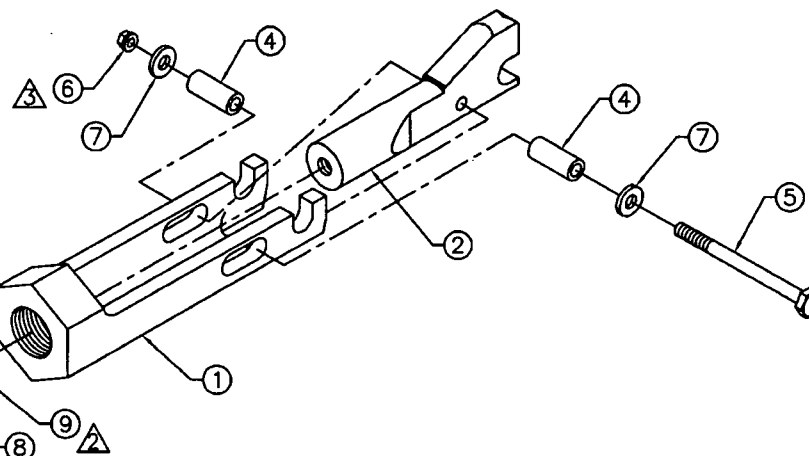
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

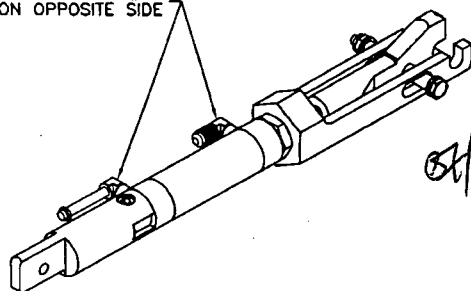
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





-001 L/H ACTUATOR ASSY



INSTALL ITEM #12
ON OPPOSITE SIDE



-002 R/H ACTUATOR ASSY

-  TORQUE 80-100 IN.-LB.
 TORQUE 20-25 IN.-LB.
 TORQUE 50-75 IN.-LB.
 TORQUE 50-75 IN.-LB.

NOTES:

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31450

			1	1	15	3/4x20 BRASS	CYLINDER NUT						
			1	1	14	MS20822-4	ELBOW						
			1	1	13	AN842-4D	ELBOW						
			1	1	12	41232-200-007-001	CYLINDER						
			1	1	11	71459	SPRING						
			1	1	10	MS16996-23	CAP SCREW						
			1	1	9	AN315-4R	NUT						
			2	2	8	AN960JD416	WASHER						
			2	2	7	AN960JD10	WASHER						
			1	1	6	MS21042-L3	NUT						
			1	1	5	AN3-22A	BOLT						
			2	2	4	41232-200-005-003	SPACER						
			1	1	3	41232-200-002-005	PIVOT ARM						
			1	1	2	41232-200-002-003	LATCH						
			1	1	1	41232-200-002-001	TUBE						
		/				-002	R/H ACTUATOR ASSY						
		/				-001	L/H ACTUATOR ASSY						
			-002	-001	FIND NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE		
LIST OF MATERIAL													
NO. REQ'D PER ASSY													
PROPRIETARY RIGHTS NOTICE THESE DATA ARE PROPRIETARY TO ERM AND/OR ITS SUBSIDIARIES. REPRODUCTION OR USE OF THESE DATA FOR ANY PURPOSE IS PROHIBITED WITHOUT WRITTEN AUTHORIZATION FROM ERM AND/OR ITS SUBSIDIARIES. DATE: 11/1/02 REV'D PER: [blank] NEXT ASSEMBLY: [blank]													
UNLESS OTHERWISE SPECIFIED X ± .1 XX ± .03 XXX ± .010 ANGLES ± .1/2°													
DRAFTSMAN D. NELSON 5/20/02 TITLE STEP ACTUATOR ASSY													
CHECK D. MURPHY 5/20/02													
STRESS													
PRGAL ENG'G DWG. SIZE C SCALE NONE													
HEAT TREAT FINISH ERA Aviation, Inc. DWG. NO. 41232-200-001 REV IF													